

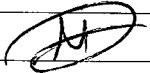
Work Order ID 131355

Monday, April 06, 2015 9:26:09 AM

131355

Page 1

Item ID: D3053-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: 212 Basket Base Ass'Y LH
Start Date: 4/06/15 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 4/16/15 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan:  Date: 15-4-6 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3053	C

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut 5 D2235-3 FROM D3166-1 using DT83

2-Drill holes in three D2235-3 ribs as per dwg D3053 using DT8995

5x CC 15-4-15

110

0.00

110

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Remove all markings from material
2-Weld as per Dwg D3053 using Welding Table and corner Jig Deburr as required****Ensure ribs are positionned for LH****

1x CC 15-4-15

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

120

QC

Memo

0.00

Quality Control

APR 15 2015
DAS
24
9-89

1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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130	QC6- Inspect dimensions to drawing	0.00							
130									DAS 24 9-89
QC	Memo	0.00							
Quality Control									
150	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
150	<i>M 131545</i>	0.00							DAS 34 9-89
Powdercoat	Memo								
Powder Coating	START TIME: <i>11:05</i> OVEN TEMPERATURE: <i>1100</i> FINISH TIME: <i>11:35</i>								<i>10 15-4-16</i>
160	QC3- Inspect Part Finish	0.00							
160									DAS 15 9-89
QC	Memo	0.00							
Quality Control									<i>1 x d all 15 out 14</i>

DQA: _____ Date: _____



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170	Identify as per dwg & Stock Location: <u>w/b</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

D205-541-013/13131353 1x 9 15/04/15

MCJ 15-04-17

CMF

15-4-17

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

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Page 1

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131355

Parent Item: D3053-041

D3053-041

Parent Item Name: 212 Basket Base Ass'Y LH

Start Date: 4/06/15

Required Date: 4/16/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP C02.09.04M304EX0.75-16F was M750-16FXS-S/SKJ/RF
IPP Rev:D 08-08-29 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304EX0.75-16F		Purchased				100	sf	1,048.861	48	51			
M304FX0 75-16F									**		<u>CC 15-4-15</u>		
Expanded Metal Flat SS													

Location	Loc Qty	Loc Code
WA004	480	
M131848	480	
WA006	568.8612	
M131107	129.8612	
M131629	439	

M304TS0.750W.065

Purchased

No

100 f

997.3500 43.3333 46

M304TS0 750W 065

304 SQ Tube .75x.75x.065W

**

CC 15-4-15

Location	Loc Qty	Loc Code
WA004	997.35	
125513	14	
m128495	389.35	
m131206	594	

D2232-3

Manufactured

No

110 Each

36.0000 2

D2232-3

Basket Hinge

**

CC 15-4-15

Location	Loc Qty	Loc Code
WA004	36	
101778	16	
115847	20	

DQA: _____ Date: _____



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D3053-041

Parent Item Name: 212 Basket Base Ass'Y LH

Start Date: 4/06/15

Required Date: 4/16/15

Start Qty: 1.00

Required Qty: 1.00

D2327-3

Manufactured No

110

Each

46.0000

2

2

D2327-3

Spacer Bushing

CC 15-4-15

Location

Loc Qty

Loc Code

WA004

46

100523

25

103679

21

D2581

Manufactured No

110

Each

83.0000

2

D2581

Mounting Bracket

CC 15-4-15

Location

Loc Qty

Loc Code

WA004

83

102265

38

127716

45

D3166-1

Manufactured No

110

Each

19.0000

5

D3166-1

Basket Hoop

CC 15-4-15

Location

Loc Qty

Loc Code

WA004

19

125268

1

125270

6

127860

12

DQA: _____ Date: _____



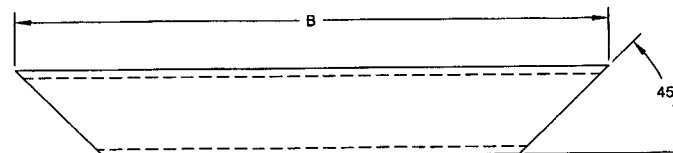
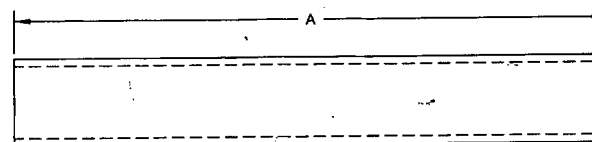
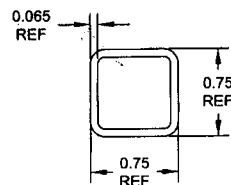
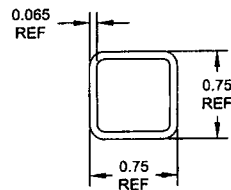
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
☐ OTHER : _____					

QTY -041	QTY -042	PART NO	LENGTH A	LENGTH B	DESCRIPTION
X		D3053-041	N/A	N/A	BASKET BASE ASSY
	X	D3053-042	N/A	N/A	BASKET BASE ASSY
2	2	D3053-1		96.00	RIB
2	2	D3053-3		25.50	RIB
6	6	D3053-5	23.73		RIB
3	3	D3053-7	25.31		RIB
3	3	D3053-9	19.48	N/A	RIB
2	2	D2327-3	N/A	N/A	BUSHING
2	2	D2581	N/A	N/A	MOUNTING BRACKET
2	2	D2232-3	N/A	N/A	HINGE PLATE
5	5	D2235-3	N/A	N/A	RIB



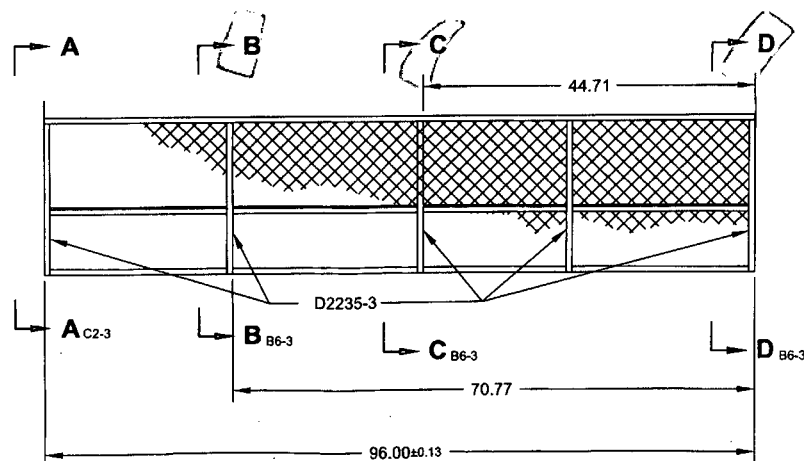
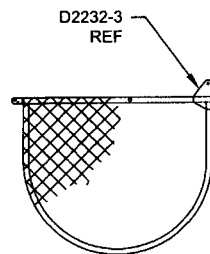
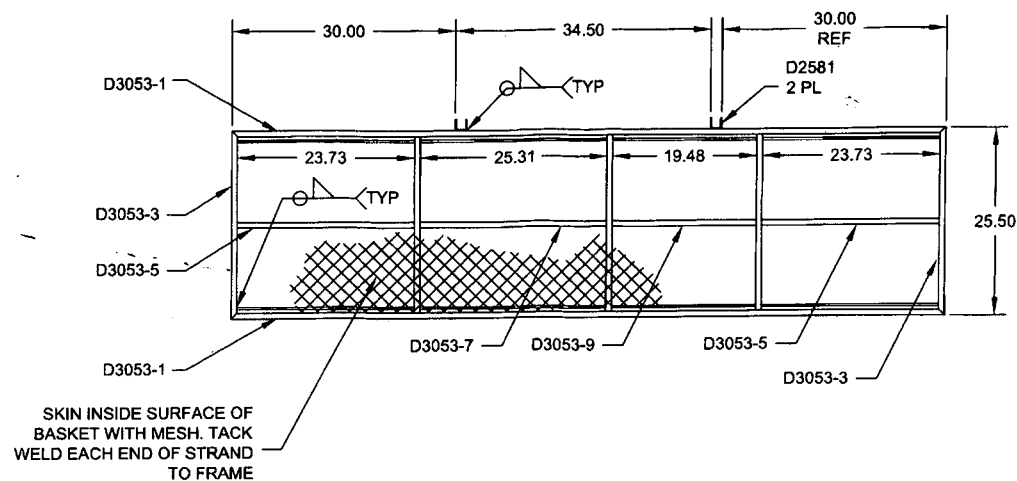
D3053-X RIB

NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 10) WELD PER DART QSI 004

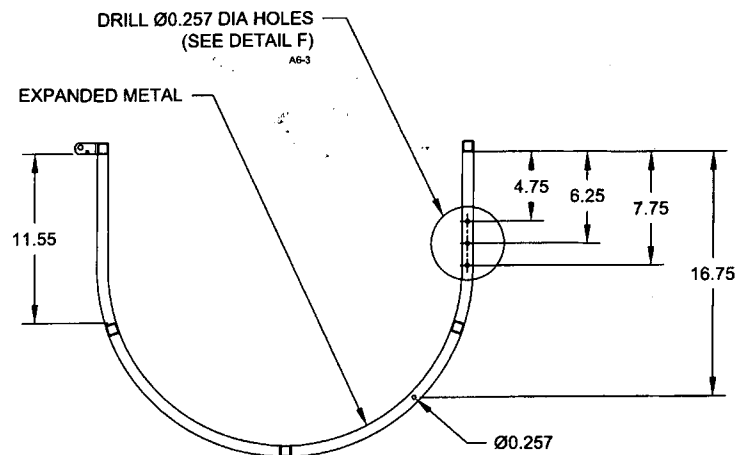
#131355
15-4-6

C	ADD -041 VIEWS, ZN B4-2, D4-2, B7-2. RE-ORGANIZE DWG. REF NCR13-2766.	DC	13.12.12
B	FRAME MATERIAL WAS 0.060 WALL. MESH MATERIAL UPDATED. DRAWING MOVED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS.	AJS	08.07.02
A	NEW ISSUE	RF	01.11.01
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D3053	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (212)	NTS
DATE	13.12.12	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



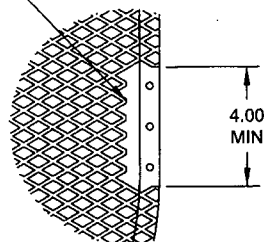
D3053-041 BASKET BASE ASSEMBLY

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D3053	SHEET 2 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (212)	NTS
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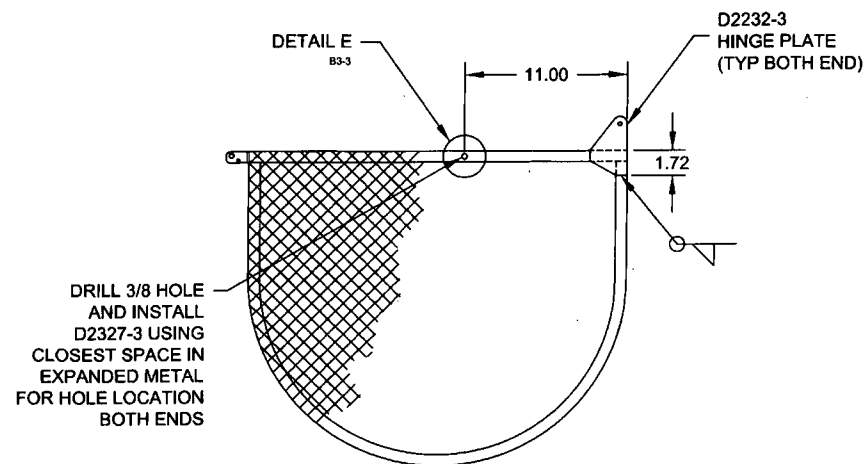


SECTION B-B
SECTION C-C
AND SECTION D-D
RIB DETAIL

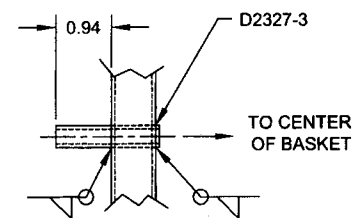
CUT AWAY EXPANDED
METAL TO NEAREST
INTERSECTIONS AS SHOWN
SECTION D-D ONLY



DETAIL F
SCALE NONE
C6-3



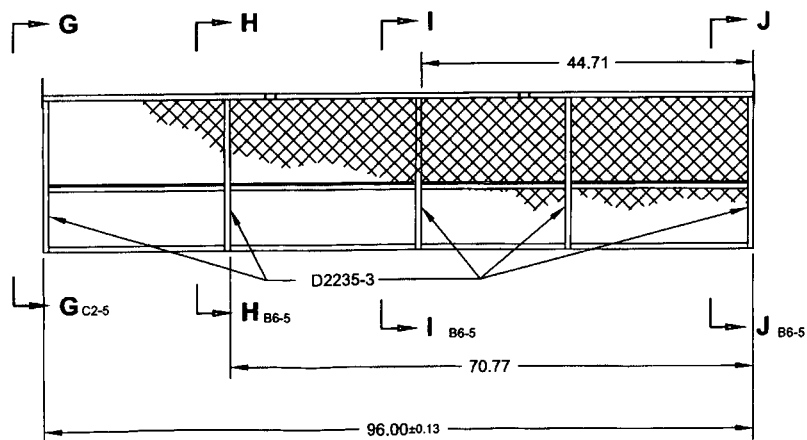
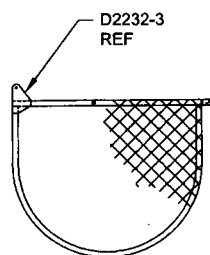
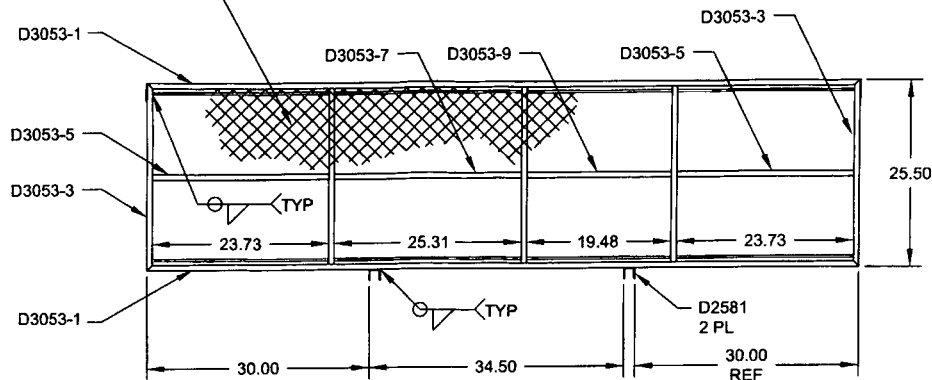
SECTION A-A
SPACER DETAIL
B6-2



DETAIL E
SCALE 4X
D2-3

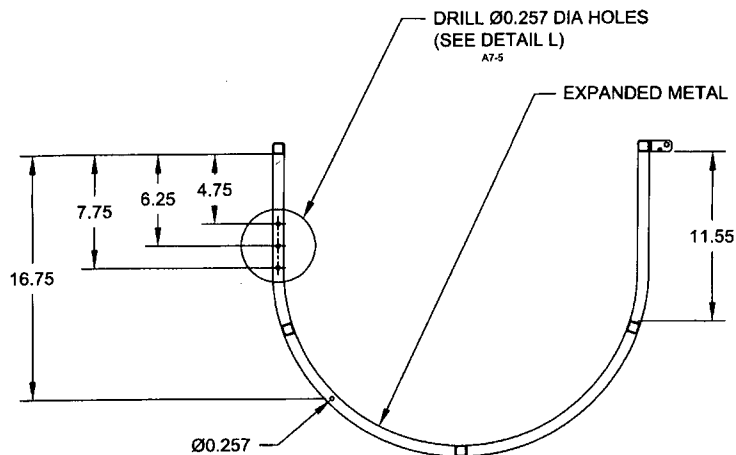
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DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D3053	SHEET 3 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (212)	NTS
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SKIN INSIDE SURFACE OF
BASKET WITH MESH. TACK
WELD EACH END OF STRAND
TO FRAME

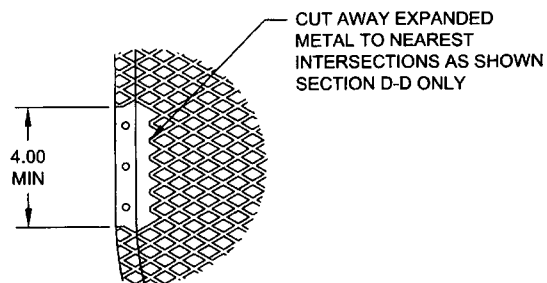


D3053-042 BASKET BASE ASSEMBLY SHOWN

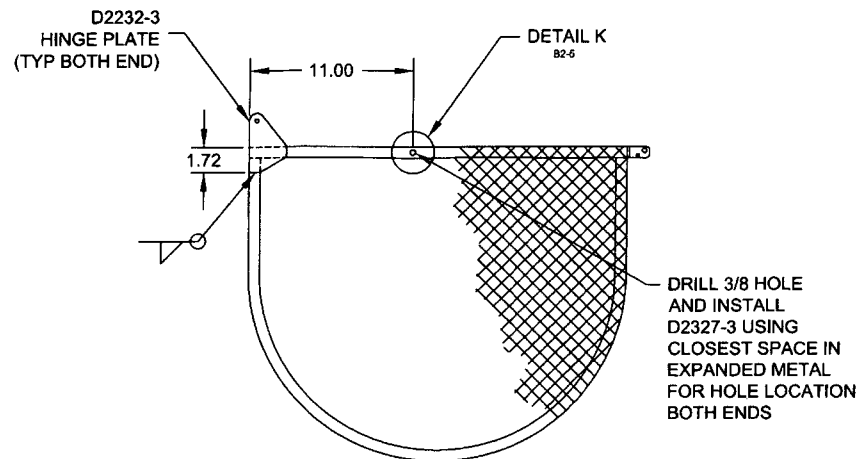
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MFG. APPR.	DD	D3053	SHEET 4 OF 5
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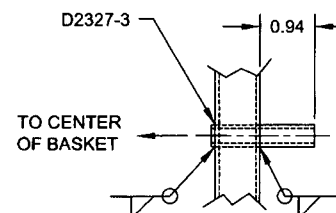
SECTION H-H_{B5-4}
SECTION I-I_{B4-4}
AND SECTION J-J_{B3-4}
RIB DETAIL



DETAIL L
SCALE NONE
C7-6



SECTION G-G_{B6-4}
SPACER DETAIL



DETAIL K
SCALE 4X
D3-5

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D3053	SHEET 5 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (212)	NTS
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